

Date: Monday, 23/02/2009 3:00:34 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DOUBLER
Job Number : 46011	
Estimate Number : 12105	
P.O. Number :	Part Number : D32011
This Issue : 23/02/2009 S.O. No. :	Drawing Number : D3201 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 45702	Material :
Written By :	Due Date : 02/03/2009
Checked & Approved By : <u>JUD 09.02.23</u>	Qty: 15 Um: Each
Comment : Est Rev:A Removed from 9 Digit 06-01-25 JLM Est Rev:B Now on Waterjet 06-08-14 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S040	2024-T3 .040 sheet
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Comment: Qty.: 0.2898 sf(s)/Unit Total : 4.3470 sf(s)
 Material: 2024-T3 (QQ-A-250/4) 0.040" thick
 (M2024T3S.040)
 Identify for D3201-1
 Batch: 110337

ml 09 02 24 (15)

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3201
 Dwg Rev: B
 Prog Rev: B

2-Deburr if necessary

ml 09 02 24 (15)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	----------------------------------------



ml 09 02 24



(15)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

S 09/02/24 (15)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

Deburr Stack

N/A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 23/02/2009 3:00:34 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 46011

Part Number: D32011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(X15)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

mo/br

09/02/24

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



9/1

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-02-24

(X13)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

ST76

AS

09/02/25

(X15)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/25

Job Completion



W 09.02.25

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

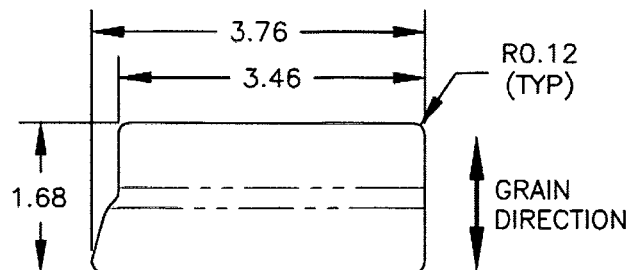
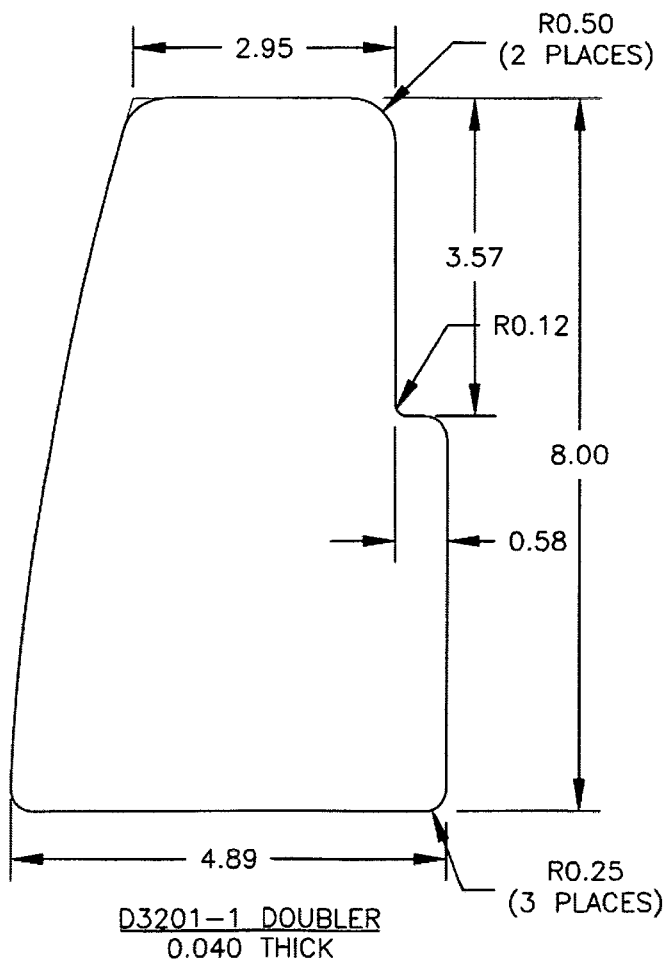
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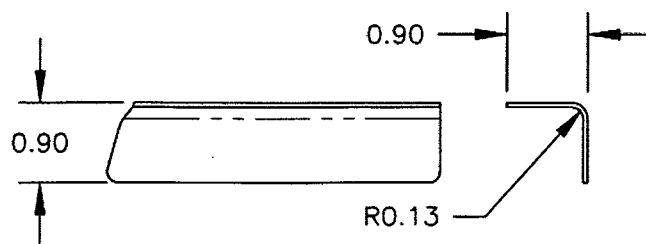


DESIGN	<i>[Signature]</i>	DRAWN BY	<i>CP</i>	DART AEROSPACE LTD	REV. B
				HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO.	SHEET 1 OF 1
				D3201	
DATE	03.11.03			TITLE	SCALE
				DOUBLER	1:2
A	03.08.07	NEW ISSUE			
B	03.11.03	MODIFY D3201-1, ADD D3201-3/-4			

RELEASED
03.11.14



D3201-3/-4 ANGLE
(FLAT PATTERN)



D3201-3 ANGLE (SHOWN)
D3201-4 ANGLE (BEND OPPOSITE)
0.050 THICK

D3201-1/-3/-4 DOUBLER

- 1) MACHINE PARTS PER DWG FILE "D3201-B1.DWG"
- 2) MATERIAL: 2024-T3 ALUMINUM SHEET (QQ-A-250/4)
(REF. DART SPEC M2024T3S)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO:
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *[Signature]*

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